

# Work Order ID 75152

**\*75152\***

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Item ID: D3065-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Spacer  
 Start Date: 18/10/2011 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 04/11/2011 Req'd Qty: 40.00 **\*40\*** Customer:

## Reference:

Approvals: Process Plan: M.L.J Date: 11/10/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100 0.00  
**\*100\*** FLOW WATER JET  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg D Dwg Rev: B Prog Rev: B 2-Debur  
2024 JWC if necessary

B11-1-2

(42)

110 0.00  
**\*110\*** QC2- Inspect parts off machine FAI/FAIB  
 QC Memo 0.00  
 Quality Control

B11-1-2

P102

120 0.00  
**\*120\*** QC8- Inspect parts - second check  
 QC Memo 0.00  
 Quality Control

W

11.11.03

(41)

W/O: 75152		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-3 PAR #: N/A Fault Category: Int Tab Water Jet NCR: Yes No DQA: h Date: 11/11/24  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/11/24

NCR: 11-1004		WORK ORDER NON-CONFORMANCE (NCR) 6.75						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/03	100	Machine error, cut hole under tolerance, and ovalized. 1 qty	<u>h</u> 11/11/03	Scrap + Destroy 1 qty	<u>AS 11-11-3</u>	<u>S</u> 11/11/04	<u>h</u> 11/11/03	<u>M/W</u> 11/11/03

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Debur Stack								
140		0.00							
<b>*140*</b>	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3065								
150		0.00							
<b>*150*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

WAS

SB 11/11/14

S 11/11/14

41

746

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 75152

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**\*75152\***

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Item ID: D3065-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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 Start Date: 18/10/2011 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 04/11/2011 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 Chemical Conversion Coat per QSI005 4.1 0.00

**\*160\***

HandFinish

Memo

0.00

Hand Finishing

41X Ø M-11/11/15

170 QC3- Inspect Part Finish 0.00

**\*170\***

QC

Memo

0.00

Quality Control

41 BP 11-11-15.

180 Identify as per dwg & Stock Location: GA 0.00

**\*180\***

Packaging

Memo

0.00

Packaging

EP 11/11/18 (41X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Item Name:** Step Spacer

**\*40\***

**Cust Item ID:**

**\*40\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

## Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00

\*190\*

OC

## Memo

0,00

## Quality Control

11/11/21

01/11/18  
(HL)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 75152

**\*75152\***

Parent Item: D3065-3

**\*D3065-3\***

Parent Item Name: Step Spacer

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF  
IPP Rev:D Now on Water Jet 06-04-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

112.5184

0.2178

9.170526

9.5

**\*M2024T3S 040\***

**\*\***

B11-11-2

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

112.518421

113162

1.1

117684

111.418421

117684

(47)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	75152
<b>Description:</b> Step Spacer		<b>Part Number:</b>	D3065-3
<b>Inspection Dwg:</b> D3065 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.260	+/-0.010	1.262	✓		V BLZ	
3.260	+/-0.010	3.261	✓		V	
5.260	+/-0.010	5.260	✓		V	
6.520	+/-0.010	6.524	✓		V	
2.093	+/-0.010	2.094	✓		V	
3.936	+/-0.010	3.940	✓		V	
4.186	+/-0.010	4.192	✓		V	
Ø0.128	+0.005/-0.000	.130	✓		V	
Ø1.250	+0.005/-0.000	1.250	✓		V	
Pitch 1.204	+/-0.005	1.204	✓		V	
0.040	+/-0.010	.043	✓		V	

<b>Measured by:</b> <i>RB</i> <b>Date:</b> 11-11-02	<b>Audited by:</b> <i>W/V</i> <b>Date:</b> 11/11/03	<b>Prototype Approval:</b> N/A <b>Date:</b> N/A
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Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	
D	07.09.06	0.040 dimension added	KJ/JLM	<i>RB</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

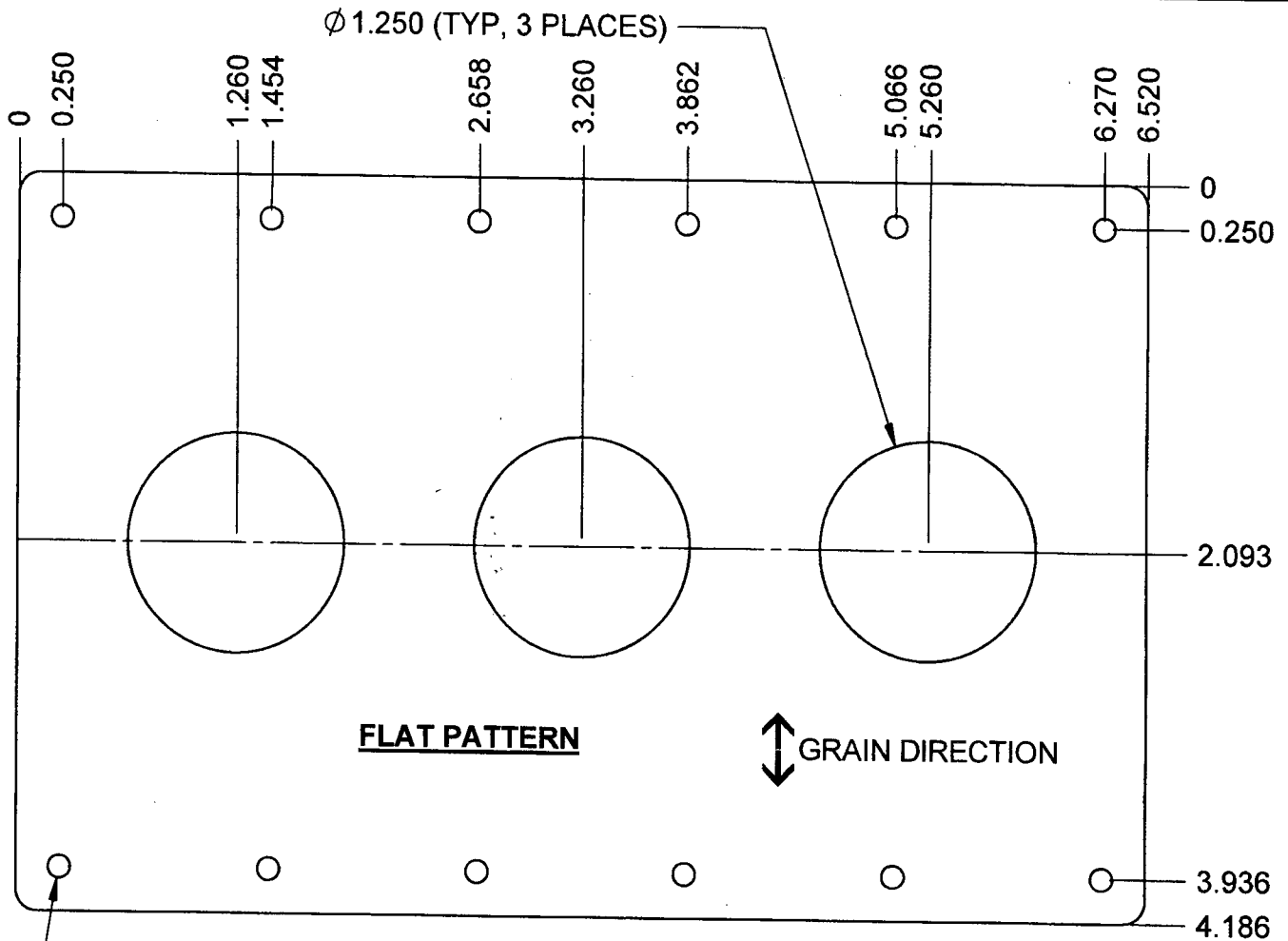
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>	REV. B SHEET 3 OF 5 SCALE 1:1

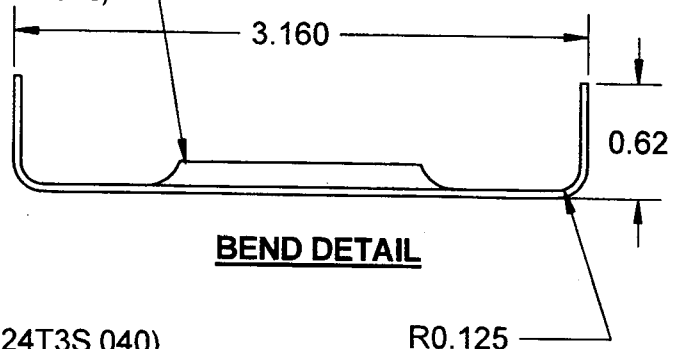


FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

**RELEASED**

*06.06.20*



**BEND DETAIL**

**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO. *75152*

*M.C.U.*  
*11/10/18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries